

**Work Order ID 58239**

Friday, April 30, 2010 3:23:44 PM

*Black*

Page 1

Item ID: D3913-041

Accept



Setup Start



Revision ID:

Stop



Item Name: Long Basket Base Assembly, 350

Start Date: 4/30/2010 Start Qty: 1.00



Cust Item ID:

Required Date: 5/24/2010 Req'd Qty: 1.00

Customer:

Reference:

Run Start

Approvals: Process Plan: *MF*Date: *10-4-30* Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D3913

A

100

Weld per dwg A/R S.S. rod Batch: *4113328* 0.00

Large Fab

Large Fab

Memo

0.00

Large Fab

1- assemble ribs, weld as per dwg D3913

\*\*\*inspect before welding mesh\*\*\*

2- tack weld mesh on basket as per dwg D3913 *JD*

3- weld hinge (3) and Mounting brackets as per dwg D3913

\*\*\*take lid to locate hinge and bracket\*\*\*

*10/05/13**10.05.19*

110

QC9- Inspect visual per QSI004- Fusion Welds

0.00



QC

Memo

0.00

Quality Control

*10.05.20*

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Item ID: D3913-041

Accept



Setup Start



Revision ID:

Stop



Item Name: Long Basket Base Assembly, 350

Start Date: 4/30/2010 Start Qty: 1.00



Cust Item ID:

Required Date: 5/24/2010 Req'd Qty: 1.00



Customer:

Reference:

Run Start



Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Stop



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

120

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

8.10/05/20

ⓧ

Quality Control

130

White Gloss(Ref:4.3.5.2) per QSI005 4.3-Steel

0.00



Powdercoat

Memo

0.00

=&gt; gel 10/05/20

1 ⓧ

Powder Coating

1- Plug holes and mask only interior of hinge (3) prior to powder coat

11/12/58

1ST COAT:

START TIME: 9:00 AM

OVEN TEMPERATURE: 320°F

FINISH TIME: 9:30 AM

\*\*\*\*\* 2nd coat if necessary\*\*\*\*\*

2ND COAT:

START TIME: 10:00 AM

OVEN TEMPERATURE: 320°F

FINISH TIME: 10:30 AM

**Work Order ID 58239**

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Item ID: D3913-041

Accept



Setup Start



Revision ID:

Stop



Item Name: Long Basket Base Assembly, 350

Start Date: 4/30/2010 Start Qty: 1.00



Cust Item ID:

Required Date: 5/24/2010 Req'd Qty: 1.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run HoursDraw  
NumberDraw  
Rev.Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

140

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

SB 12/05/20



Quality Control

150

Assemble as per dwg

0.00



HandFinish

Memo

0.00

Hand Finishing

Pick Kit

SB 12/05/20

160

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

SB 12/05/20



Quality Control

**Work Order ID 58239**

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Item ID: D3913-041

Accept



Setup Start



Revision ID:

Stop



Item Name: Long Basket Base Assembly, 350

Start Date: 4/30/2010 Start Qty: 1.00



Cust Item ID:

Required Date: 5/24/2010 Req'd Qty: 1.00



Customer:

Reference:

Run Start



Approvals: Process Plan: \_\_\_\_\_

Date: \_\_\_\_\_

Tooling: \_\_\_\_\_

Date: \_\_\_\_\_

Stop



QC: \_\_\_\_\_

Date: \_\_\_\_\_

SPC (Y/N): \_\_\_\_\_

Date: \_\_\_\_\_

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run HoursDraw  
NumberDraw  
Rev.Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

170

Identify as per dwg & Stock Location: *G-A* 0.00

Packaging

Memo

0.00

Packaging

*ES 10/05/2010*

180

QC21- Final Inspection - Work Order Release 0.00



QC

Memo

0.00

Quality Control

*10/05/2010**W 10/05/20*

# Picklist Print

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Page 1

Work Order ID: 58239



Parent Item: D3913-041



Parent Item Name: Long Basket Base Assembly, 350

Start Date: 4/30/2010

Required Date: 5/24/2010

Comments: IPP Rev:A new issue DD 10.03.19 verified by:EC  
chg qty's DD 10.04.12 verified by:EC

IPP Rev:B

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Qty Issued	Date Issued	Status
AN3-10A		Purchased	No			150	Each	112.0000	6			
Bolt												

Location	Loc Qty	Loc Code
ST351	112	
111119	12	
114330	100	

AN960JD8		Purchased	No			150	Each	0.0000	2			
Washer												
D2581		Manufactured	No			100	Each	27.0000	2			
Mounting Bracket												

N 112 314

Location	Loc Qty	Loc Code
WA	27	
46086	2	
51745	2	
57185	23	

D2931		Manufactured	No			150	Each	872.0000	2			
Bumper												

Location	Loc Qty	Loc Code
ST504	872	
46064	872	

D3913-1		Manufactured	No			100	Each	0.0000	1			
Rib												

6 SS 10/05/20

SS 10/05/20

SS 10/05/12

2

2 SS 10/05/20

B58/24 ① SS 10/05/12

# Picklist Print

Page 2

Friday, April 30, 2010 3:23:43 PM

Work Order ID: 58239



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Parent Item Name: Long Basket Base Assembly, 350

Start Date: 4/30/2010

Required Date: 5/24/2010

Comments: IPP Rev:A new issue DD 10.03.19 verified by:EC  
chg qty's DD 10.04.12 verified by:EC

IPP Rev:B

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	---------------	----------------	--------

✓ D3913-15  
  
Wide Handle Plate

Manufactured No

100

Each

2.0000

1



B58125 ① SM 10/05/12

Location

Loc Qty

Loc Code

WA

2

57079

2

✓ D3913-3

Manufactured No

100

Each

7.0000

1

Rib



SM 10/05/12

Location

Loc Qty

Loc Code

WA

7

57609

1

58126

6

✓ D3913-7

Manufactured No

100

Each

0.0000

2

Rib



B 58127 ② SM 10/05/12

✓ D3913-9

Manufactured No

100

Each

1.0000

1

Hinge Rib



B58128 ① SM 10/05/12

Location

Loc Qty

Loc Code

WA

1

57610

1

✓ D3916-041

Manufactured No

100

Each

0.0000

2

Rib Assembly



B58357 ② SM 10/05/12

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Shop Packet Print

Page 2

# Picklist Print

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Parent Item: D3913-041



Parent Item Name: Long Basket Base Assembly, 350

Start Date: 4/30/2010

Required Date: 5/24/2010

Comments: IPP Rev:A new issue DD 10.03.19 verified by:EC  
chg qty's DD 10.04.12 verified by:EC

IPP Rev:B

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Qty Issued	Date Issued	Status
✓ D3916-5  Light Rib		Manufactured	No			100	Each	2.0000	3			
				<u>Location</u>				<u>Loc Qty</u>				
				WA				2				
					57023			2				
✓ D4016-1  Hinge Half, Base		Manufactured	No			100	Each	4.0000	3			
				<u>Location</u>				<u>Loc Qty</u>				
				ST109				4				
					57611			4				
✓ D4017-7  Rib		Manufactured	No			100	Each	0.0000	1			
✓ D4017-9  Rib		Manufactured	No			100	Each	12.0000	2			
				<u>Location</u>				<u>Loc Qty</u>				
				WA				12				
					58134			12				
D4020-1  Mesh (350 Basket Long, Base)		Manufactured	No			100	Each	0.0000	1			
				<u>Location</u>				<u>Loc Qty</u>				
				WA				12				
					58134			12				



B58360 ③ 10/05/12



B58132 ③ 10/05/12



B57989 ① 10/05/12



B58134 ② 10/05/12



10.05.19  
B58708 → ①

# Picklist Print

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Parent Item: D3913-041

Parent Item Name: Long Basket Base Assembly, 350

Start Date: 4/30/2010

Required Date: 5/24/2010

Comments: IPP Rev:A new issue DD 10.03.19 verified by:EC  
chg qty's DD 10.04.12 verified by:EC

IPP Rev:B

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Qty Issued	Date Issued	Status
D4020-11 End Mesh, Basket		Manufactured	No			100	Each	1.0000	2			
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>				
				WA		1						
					56990	1						
✓ D4021-1 Handle Plate		Manufactured	No			100	Each	7.0000	3			
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>				
				ST109		7						
					57086	7						
D4021-5 Blanking Plate		Manufactured	No			150	Each	4.0000	2			
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>				
				ST109		4						
					57612	4						
✓ D4034-041 Aft Upper Rib Assembly		Manufactured	No			100	Each	4.0000	1			
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>				
				WA		4						
					57988	4						

PD 10.05.19  
B58136 → ②

B58139 ③ SM 10/05/12

2 SS 10/05/12  
B58141 ① SM 10/05/12

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Shop Packet Print

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Start Date: 4/30/2010

Required Date: 5/24/2010

Comments: IPP Rev:A new issue DD 10.03.19 verified by:EC  
chg qty's DD 10.04.12 verified by:EC

IPP Rev:B

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Qty Issued	Date Issued	Status
✓ D4034-043		Manufactured	No			100	Each	4.0000	1			



Fwd Upper Rib Assembly



1358142 ① 10/05/12

Location	Loc Qty	Loc Code
WA	4	
58040	4	

MS20600-AD4W3 Purchased No

150 Each 1,891.000 2



Cherry Rivets



Location	Loc Qty	Loc Code
ST321	1891	
106375	3	
107939	888	
111636	1000	

MS21042L3 Purchased No

150 Each 1,776.000 6



Nut



2 8B 10/05/20

Location	Loc Qty	Loc Code
ST300	1776	
113537	20	
113644	756	
114523	1000	

NAS1149F0332P Purchased No

150 Each 959.0000 12



WASHER

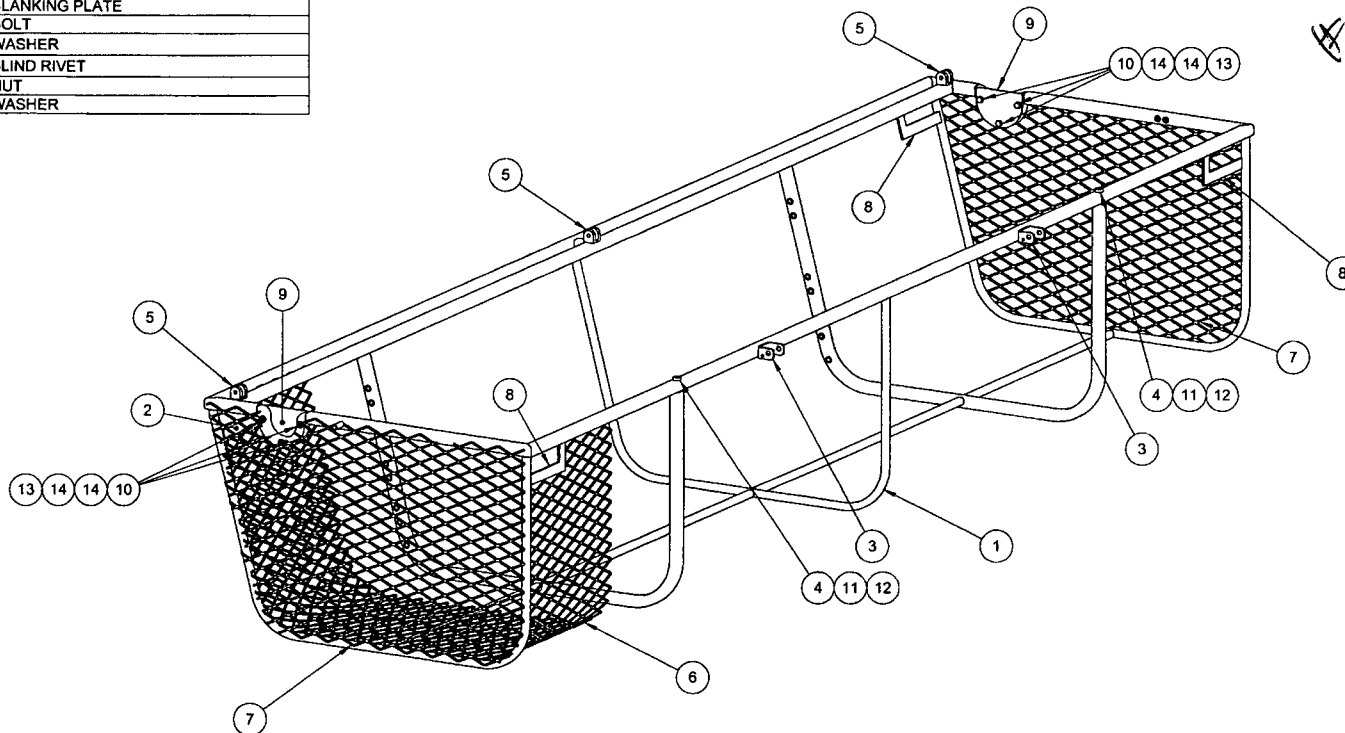


6 8B 10/05/20

Location	Loc Qty	Loc Code
ST275	959	
18057	959	

12 8B 10/05/20

ITEM	QTY	P/N	DESCRIPTION
	X	D3913-041	LONG BASKET BASE ASSY (350)
1	1	D3913-101	TUBULAR ASSY (350 SHORT BASKET)
2	1	D3913-15	WIDE HANDLE PLATE
3	2	D2581	MOUNTING BRACKET
4	2	D2931	BUMPER
5	3	D4016-1	HINGE HALF, BASE
6	1	D4020-1	MESH (350 BASKET LONG BASE)
7	2	D4020-11	END MESH, BASKET
8	3	D4021-1	HANDLE PLATE
9	2	D4021-5	BLANKING PLATE
10	6	AN3-10A	BOLT
11	2	AN960JD8	WASHER
12	2	MS20600AD4W3	BLIND RIVET
13	6	MS21042L3	NUT
14	12	NAS1149F0332P	WASHER



**D3913-041 LONG BASKET BASE ASSY (350)**  
(MESH SHOWN LOCALLY FOR CLARITY)

**NOTES:**

- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 43.3 lbs APPROX
- 8) INSTALL AFTER FINISH
- 9) MASK HOLES PRIOR TO POWDER COAT
- 10) WELD PER DART QSI 004

**RELEASED**  
2010-03-22  
JPH

A	NEW ISSUE	JPH	10.03.16
REV.	DESCRIPTION	BY	DATE
DESIGN	AJS		
DRAWN	JPH		
CHECKED			
MFG. APPR.			
DE APPR.			
DATE	10.03.16		

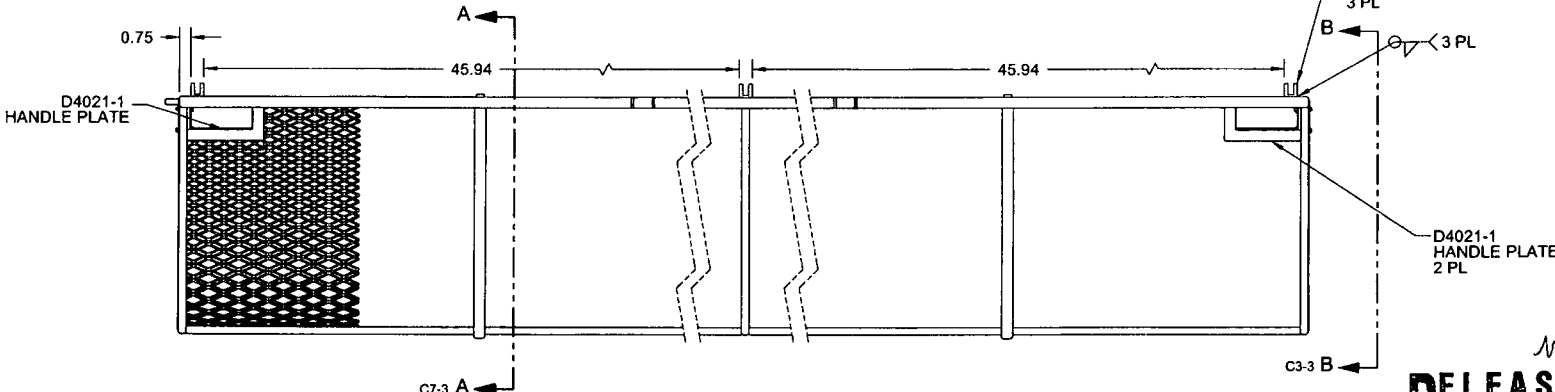
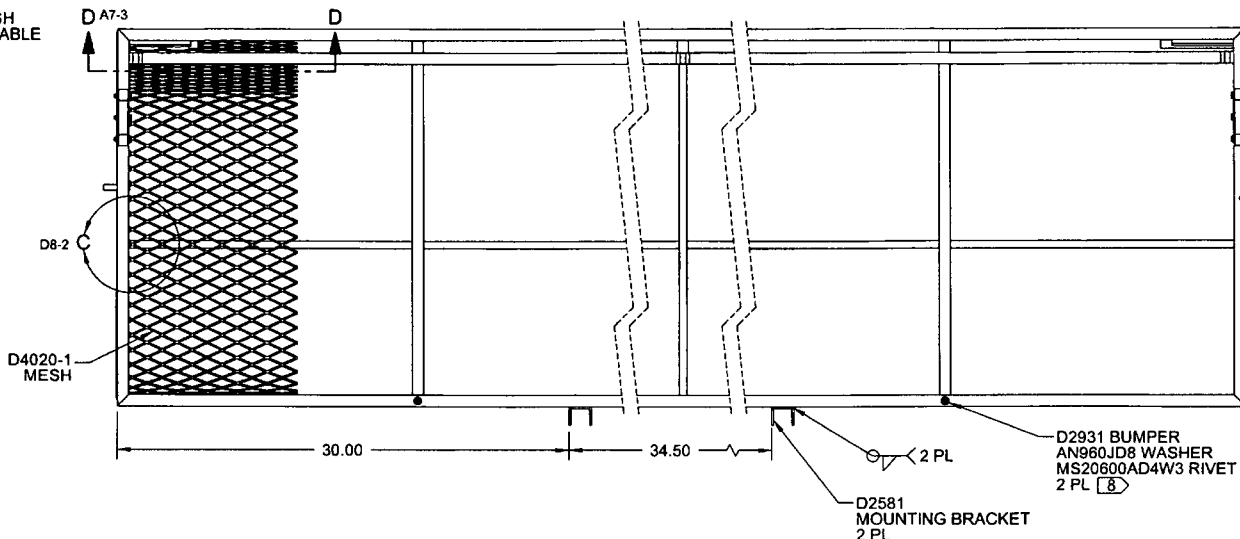
**DART AEROSPACE LTD**  
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. **D3913** REV. A  
SHEET 1 OF 6  
TITLE **LONG BASKET BASE ASSY (350)** SCALE NTS

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TACK WELD MESH  
AT EVERY AVAILABLE  
LOCATION

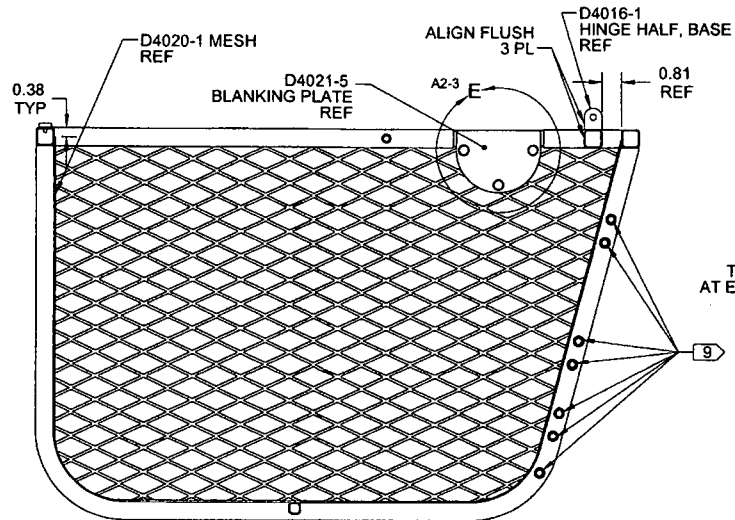
**DETAIL C** D7-2



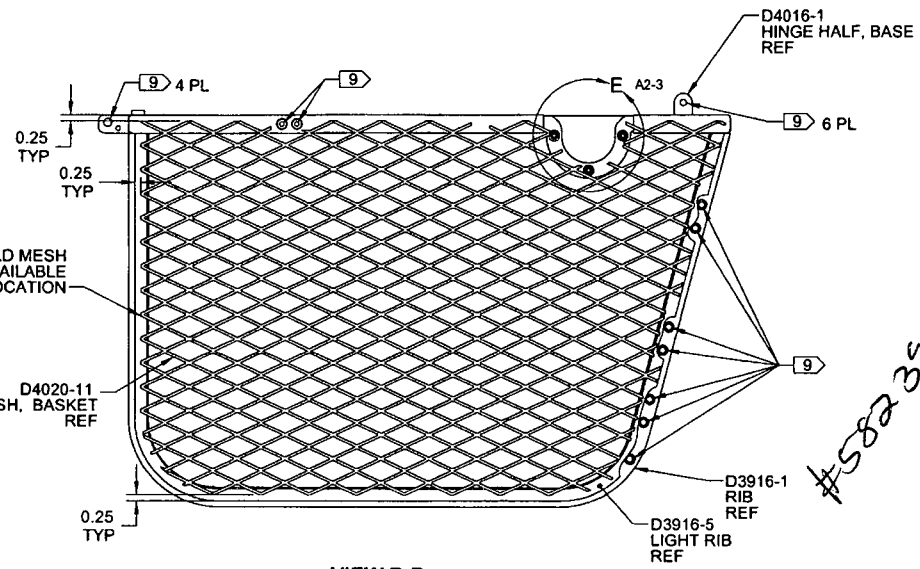
**D3913-041 LONG BASKET BASE ASSY (350)**  
(MESH SHOWN LOCALLY FOR CLARITY)

**RELEASED**  
2010-03-27

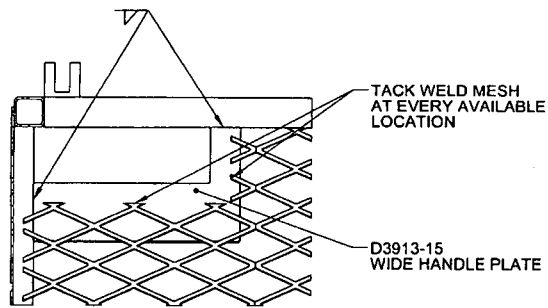
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DRAWN	JFH	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.	<del>1</del>	D3913	SHEET 2 OF 6
APPROVED	<del>1</del>	TITLE	SCALE
DE APPR.	<del>1</del>	LONG BASKET BASE ASSY (350) NTS	
DATE	10.03.16	COPYRIGHT © 2010 BY DART AEROSPACE LTD	
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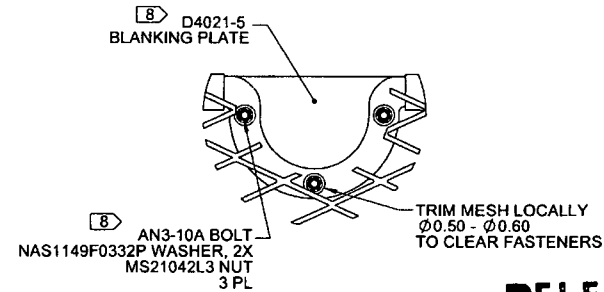
**SECTION A-A** A5-2







**VIEW B-B** A2-2



**SECTION D-D** D7-2  
TYPICAL FOR ALL  
HANDLE PLATES



**DETAIL E** D2-3  
D6-3

DESIGN	AJS	<b>DART AEROSPACE LTD</b>	
DRAWN	JRH	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		<b>D3913</b>	SHEET 3 OF 6
APPROVED		TITLE	SCALE
DE APPR.		<b>LONG BASKET BASE ASSY (350)</b>	NTS
DATE	<b>10.03.16</b>	COPYRIGHT © 2010 BY DART AEROSPACE LTD	
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**RELEASED**  
2010-03-22

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

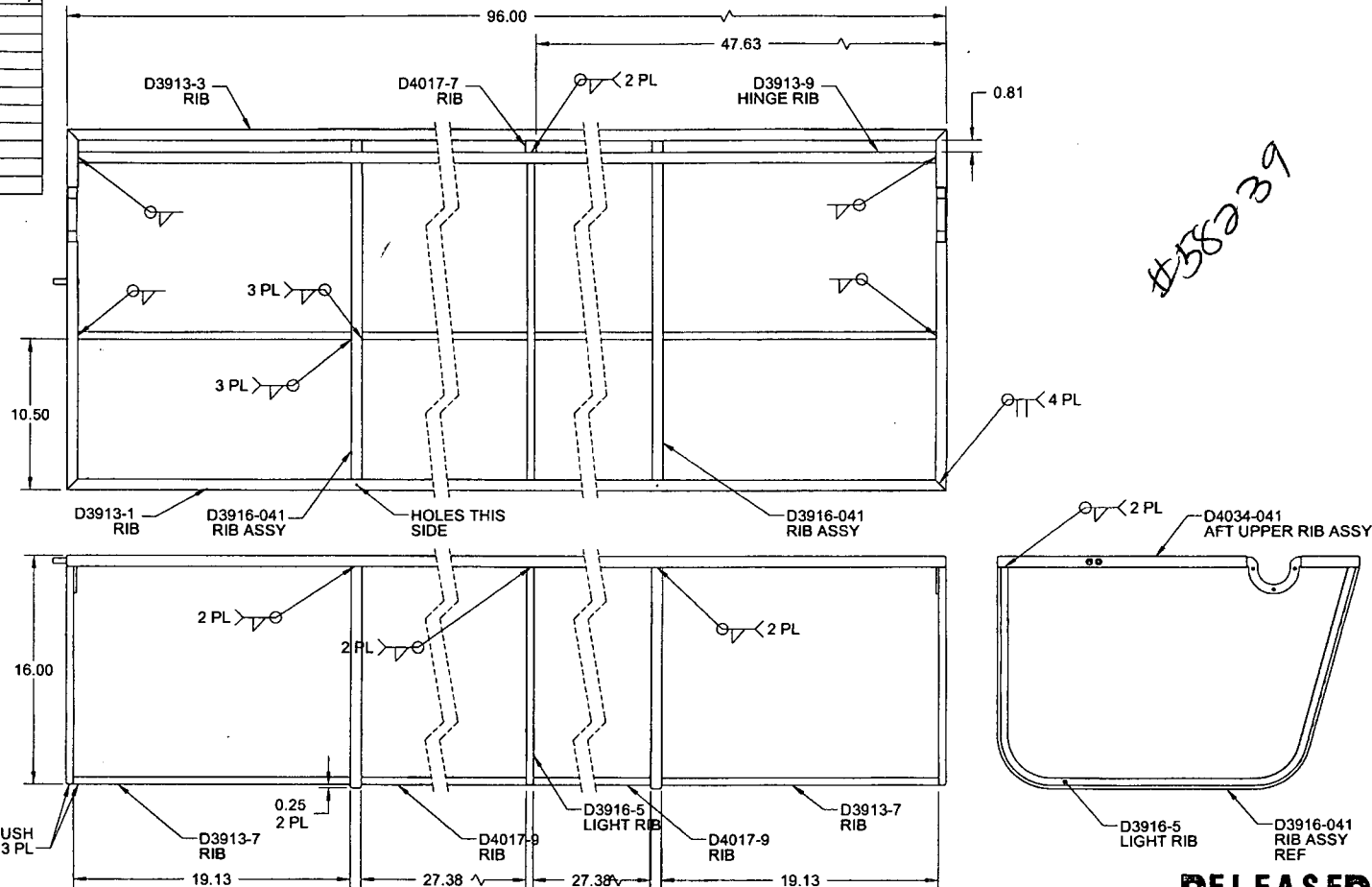
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

ITEM	QTY	P/N	DESCRIPTION
	X	D3913-101	TUBULAR ASSY (350 LONG BASKET)
1	1	D3913-1	RIB
2	1	D3913-3	RIB
3	2	D3913-7	RIB
4	1	D3913-9	HINGE RIB
5	3	D3916-5	LIGHT RIB
6	2	D3916-041	RIB ASSY
7	1	D4017-7	RIB
8	2	D4017-9	RIB
9	1	D4034-041	AFT UPPER RIB ASSY
10	1	D4034-043	FWD UPPER RIB ASSY



8 D3913-101 TUBULAR ASSY (350 SHORT BASKET)

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 22.53 lbs
- 8) TOLERANCE FOR XX.XX DIMENSIONS  $\pm 0.06$  FOR D3913-101
- 9) WELD PER DART QSI 004

DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	JPH		
CHECKED	A	DRAWING NO. D3913	REV. A
MFG. APPR.			SHEET 4 OF 6
APPROVED		TITLE LONG BASKET BASE ASSY (350)	SCALE NTS
DE APPR.		COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	
DATE	10.03.16		

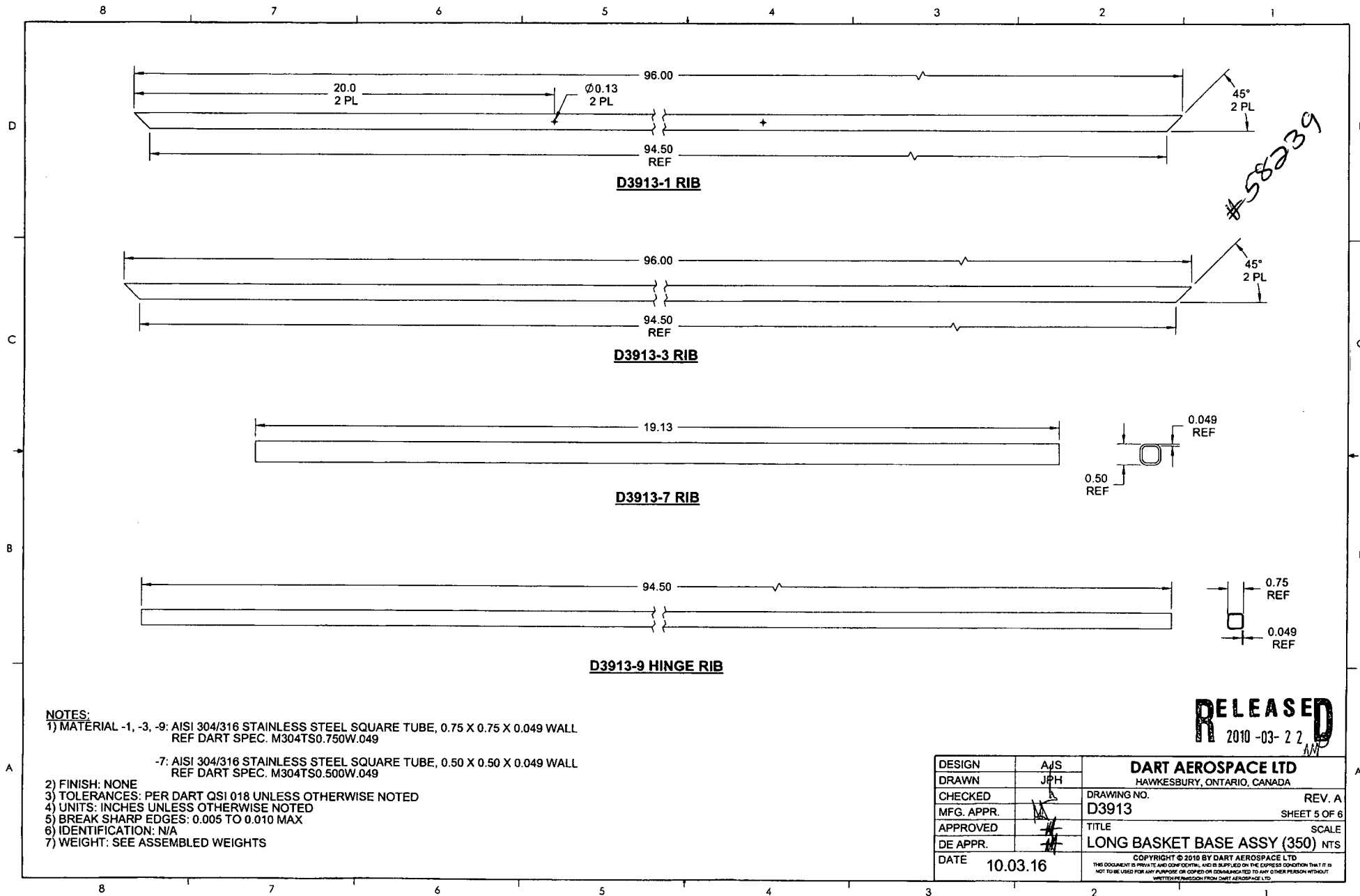
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries





W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

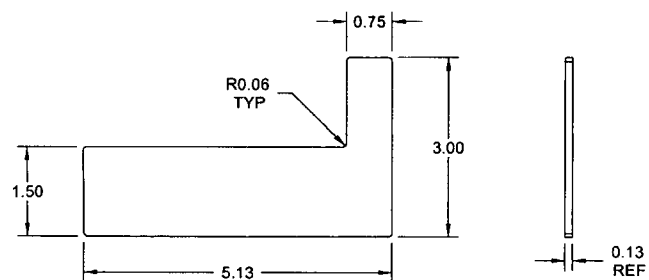
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

#58239



**D3913-15 WIDE HANDLE PLATE**

**NOTES:**

- 1) MATERIAL: 304/316 STAINLESS STEEL SHEET ANNEALED 2B FINISH,  
PER MIL-S-5059 OR AMS 5513/5524 OR ASTM A240 OR ASME SA240  
REF DART SPEC M304S11GA
- 2) FINISH : NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.31 lbs

**RELEASED**  
2010-03-22  
JAP

DESIGN	AJS	<b>DART AEROSPACE LTD</b>	
DRAWN	JRH	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D3913	SHEET 6 OF 6
APPROVED		TITLE	SCALE
DE APPR.		LONG BASKET BASE ASSY (350)	NTS
DATE	10.03.16	<small>COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR DISSEMINATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries